

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021807**Date Inspected:** 28-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Steel Barrier**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

Bay 14

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Shielded Metal Arc Welding (SMAW), and the Flux Cored Arc Welding (FCAW) processes.

ZPMC QC is identified as Zhu Yuan Yuan.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Deck Plate

PCMK: DP3102-001

Weld Number: 253

Welder: 044790

WPS-B-T-2233-ESAB

Component: Deck Plate

PCMK: SEG3011J

Weld Number: 002

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Welder: 206623
WPS-B-T-2233-ESAB

Component: Deck Plate
PCMK: DP3163-001
Weld Number: 025
Welder: 215553
WPS-345-SMAW-2G-FCM-REPAIR
WR 20222

Component: Deck Plate
PCMK: DP3167-001
Weld Number: 037
Welder: 050969
WPS-345-SMAW-2G-FCM-REPAIR
WR 20271

Component: Deck Plate
PCMK: DP3160-001
Weld Number: 004
Welder: 044631
WPS-345-SMAW-2G-FCM-REPAIR
WR 20249
Bay 16

This QA Inspector observed the following work in progress for Bay 16.
ZPMC was using the Flux Cored Arc Welding (FCAW) processes.
ZPMC QC is identified as Guo Xing Hui.
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Component: Steel Barrier
PCMK: W2-SB27-005
Weld Number: 048, 049
Welder: 048625
WPS-B-T-2133-ESAB

Component: Steel Barrier
PCMK: W2-SB16B-001
Weld Number: 082, 086
Welder: 201889
WPS-B-T-2132-ESAB

Component: Steel Barrier

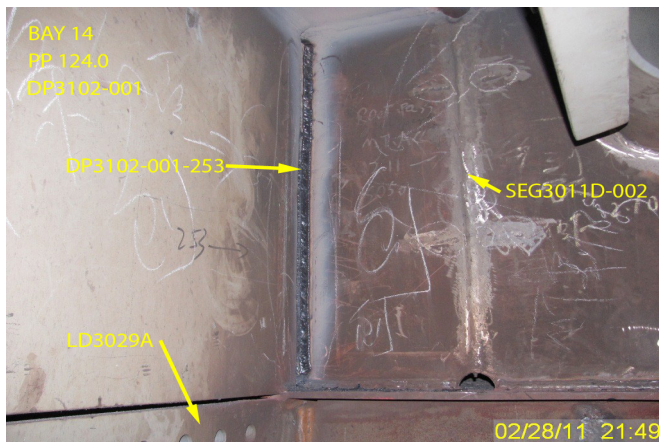
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PCMK: W2-SB27-003
Weld Number: 079, 080
Welder: 201888
WPS-B-T-2133-ESAB

Component: Steel Barrier
PCMK: W2-SB27-001
Weld Number: 126~131
Welder: 201074
WPS-B-T-2132-ESAB

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for

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your project.

Inspected By: Combs,Dennis

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer